

Work Order ID 84006-1/2

84006

Page 1

Item ID: D2332-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M65

Date: 12/05/01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

100

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00

110

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

10

φ

FF 12-08-10

10

φ

FF 12-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-01-12 10:40:07 AM

Page 2

12-8-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84006

May-01-12 10:40:07 AM

84006

Page 3

Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 6.69" long
 Start Date: 01/05/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 15/05/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
			DAS 10	12.08.13					
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			SMB 12-8-13	DAS 16 12/08/13		6			
170 *170* Small Fab Small Fab	1- Tumble 2- Assemble as per dwg D2332	0.00 0.00							
						6	φ		FF 12-08-14 JM 12-8-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84006

May-01-12 10:40:07 AM

84006

Page 4

Item ID: D2332-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lid Prop Assembly 6.69" long
 Start Date: 01/05/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 15/05/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 255 Memo	0.00 0.00							
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MLJ 12/08/14

12/08/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:40:10 AM

Page 2

Work Order ID: 84006

84006

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased

No

170

Each

83.0000

1

10

AN4-4A

Bolt

**

⑥ FF 12-08-14

Location

Loc Qty

Loc Code

FP001

6

114615

6

ST355

77

120187

31

121285

46

AN960JD416L

NAS1149D0416J

Purchased

No

170

Each

8.0000

3

30

*AN960JD416I *

Washer

**

⑥ FF 12-08-14

Location

Loc Qty

Loc Code

FP002

8

110153

8

MS21042L4

Purchased

No

170

Each

5,520.000

1

10

MS21042I 4

Nut

**

⑥ FF 12-08-14

Location

Loc Qty

Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

May-01-12 10:40:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

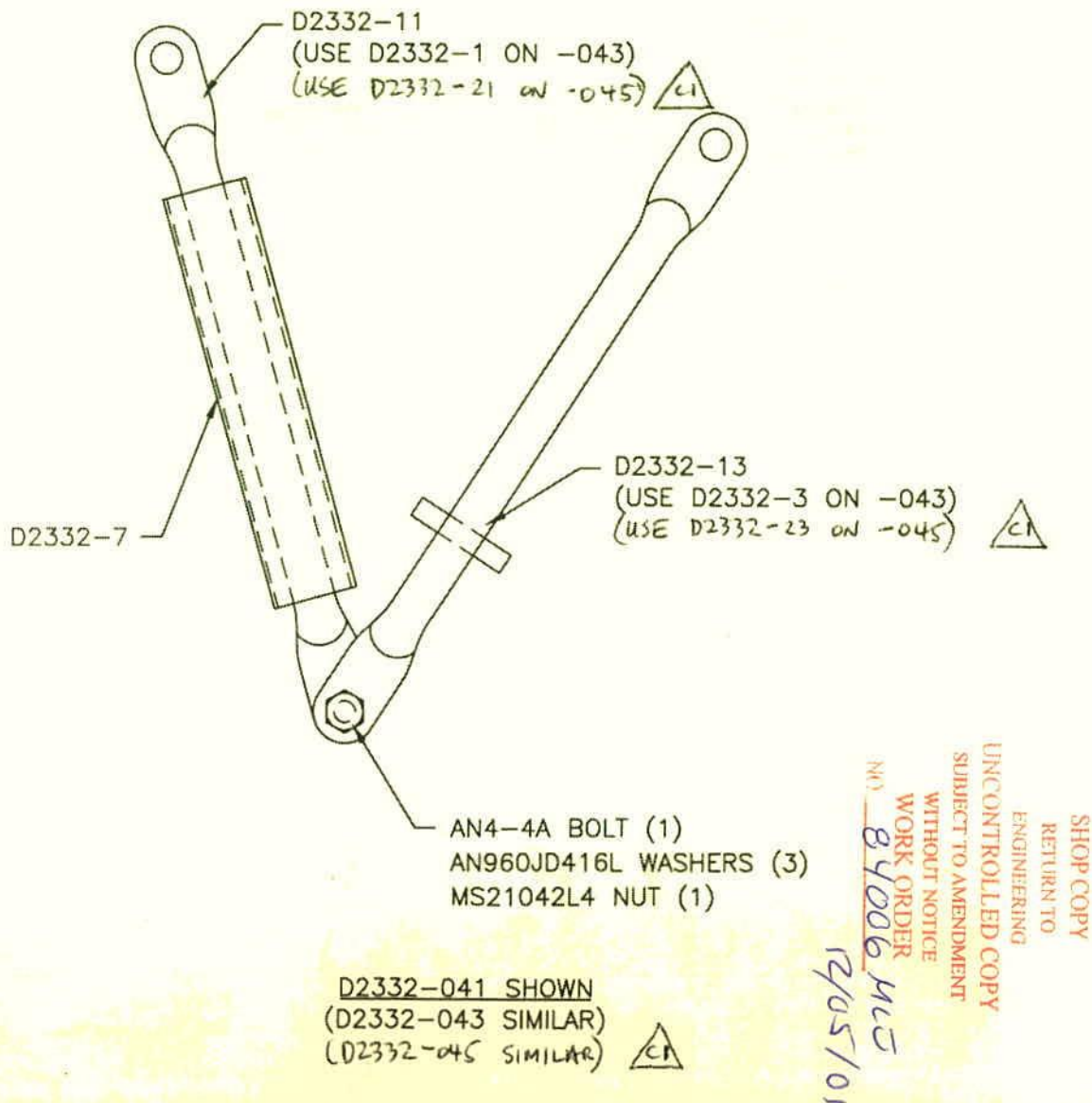
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NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	# 4/ 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

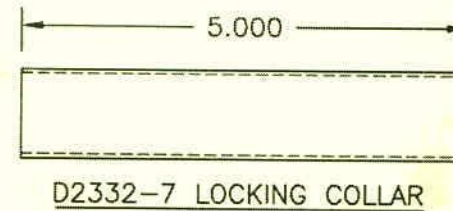
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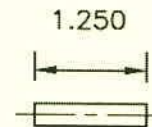
DART

DESIGN	DRAWN BY	DRAWING NO.	REV. C
#	#	D2332	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	TITLE	SHEET 2 OF 2
#	#	LID PROP ASSEMBLY	SCALE
DATE			1:2
03.07.03			
C	03.07.03	MAKE -041 PROP 6.69" LONG (LTD)	
C1	03.08.06	MAKE -043 PROP 8.00" LONG (LTD)	
		ADD -045 PROP 7.25" LONG	

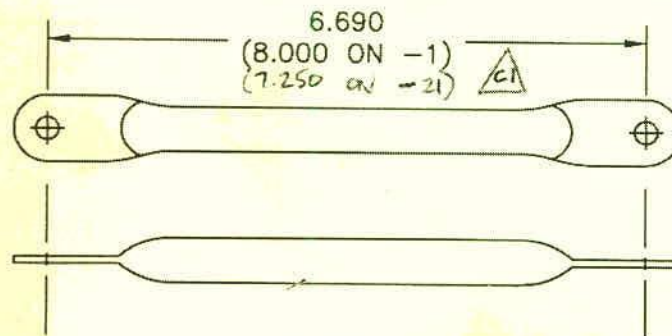
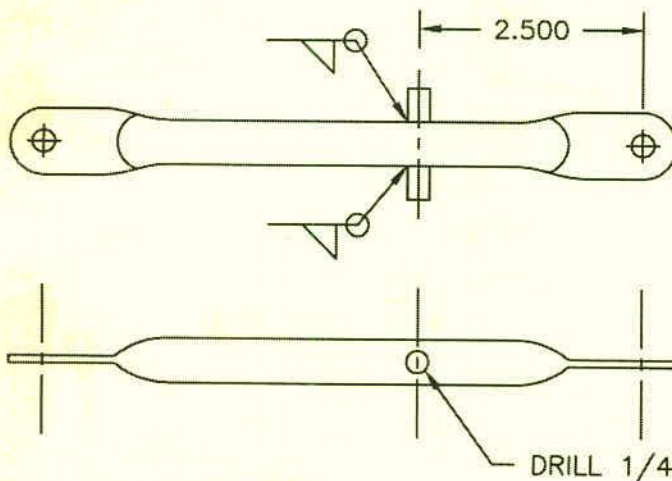
84006



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

D2332-11 PROP
(D2332-1 SIMILAR)

D2332-13

M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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